

# Work Order ID 53663

November 11, 2009 3:45:58 PM



Page 1

Item ID: D2252-13

Accept



Setup Start



Revision ID: G

Stop



Item Name: Frame

Start Date: 11/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 18/11/2009 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:   *PL*  

Date: 09-11-12 Tooling:                     

Date:                     

Run Start



QC:                     

Date:                      SPC (Y/N):                     

Date:                     

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2252	G

100 0.00



Large Fab

Memo

0.00

Large Fab

1- Cut as per dwg D2252  
2- Deburr and remove identification markings on tube

SAD 09-12-02

2

110 0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

> Jorizler

42

120 0.00



Packaging

Identify as per dwg & Stock Location: WA

Memo

0.00

Packaging

SAD 09-12-02

2

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Page 2

Item ID: D2252-13

Accept



Setup Start



Revision ID: G

Stop



Item Name: Frame

Start Date: 11/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 18/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/03

R 0912-3

(2)

# Picklist Print

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Page 1

Work Order ID: 53663



Parent Item: D2252-13RevG



Parent Item Name: Frame

Start Date: 11/11/2009

Required Date: 18/11/2009

Comments: IPP Rev:A 09.03.18 New Issue EC verified by:DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304TS0.750W.065

Purchased

No

100

f

479.3370

7.3684



SAD 09-12-02

304 SQ Tube .75x.75x.065W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

473.6842

113082

473.6842

Main Warehouse

WA

5.6527947

112398

5.6527947

M113245 → 7.3684

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2252-041	BASKET ASSEMBLY
3		X	D2252-043	LID ASSEMBLY
7	2	2	D2221-1	RIB
8	5		D2235-1	RIB
9	2	2	D2252-1	FRAME
10		2	D2252-7	FRAME
11	1		D2252-9	FRAME
12	1		D2252-11	FRAME
13	1		D2252-13	FRAME
14	1		D2252-15	FRAME
15	4		D2252-17	FRAME
16		1	D2252-23	FRAME
17	2		D2253-1	LUG
18	2		D2254	GUSSET
19	1	1	D2327-3	BUSHING
20		1	D2329	LABEL PLATE
21	4	2	D2581	MOUNTING CHANNEL
22		2	D2989-19	RIB
23	3		D3748-1	HINGE HALF
24		3	D3749-1	HINGE HALF

SHOP COPY  
RETURNED  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO APPROVAL  
WITHOUT FINAL  
WORK ORDER

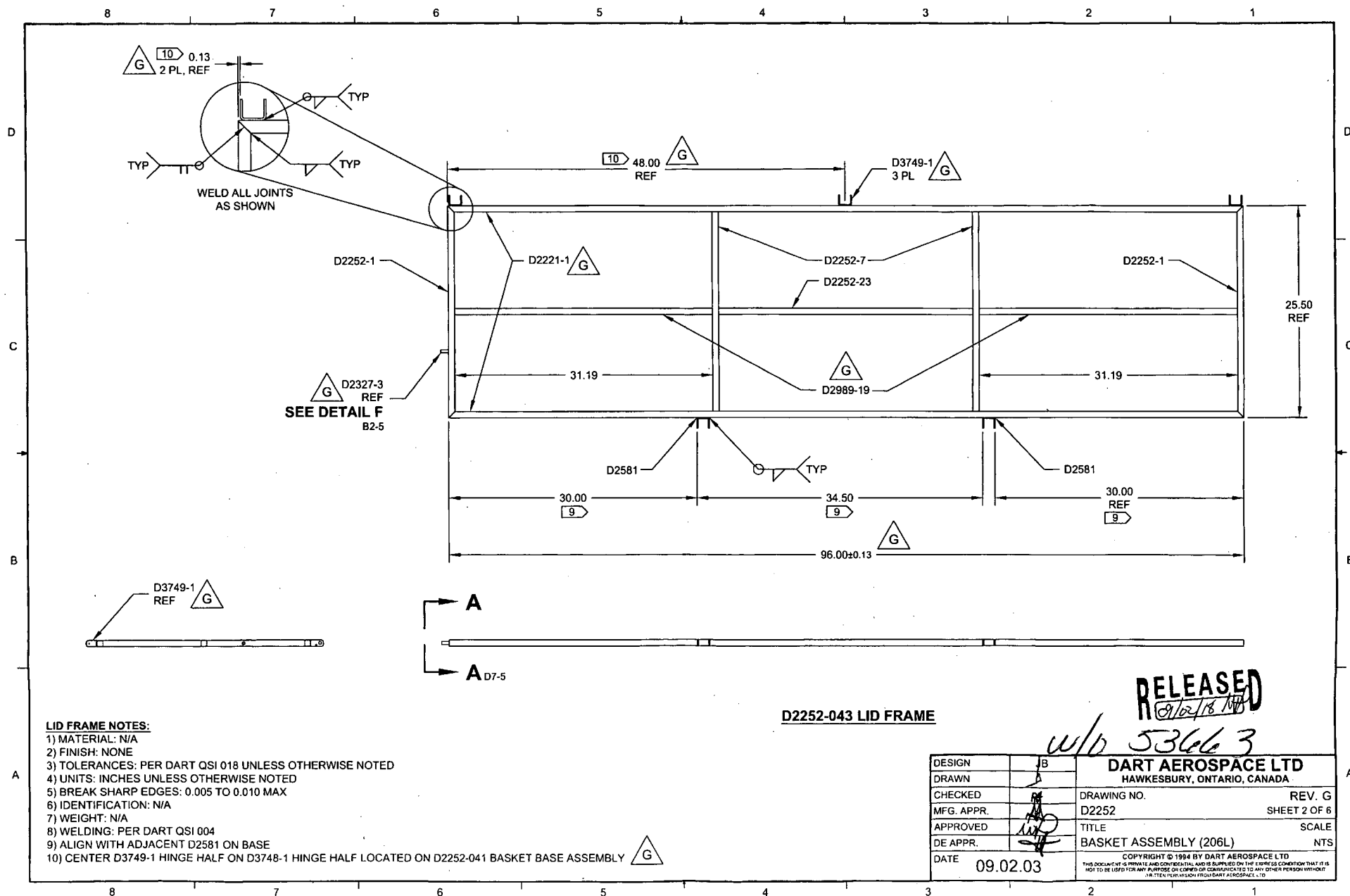
NO. 53663  
9/09-11-12

RELEASED  
9/10/18

**NOTES:**

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004




G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1/-3; STRETCHED LID FROM 95.27" TO 96.00"; ITEM 7 REPLACES D2252-3/-19; ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (ZN A6-5). P/N REASON: SEE PAR#09-006.	MB	09.02.03
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1 & D2. ADDED D2231-1/-3 & D2252-19.	MB	05.11.10
D	MODIFIED LATCH, D2581 WAS D2255-3	BK	99.09.14
C	RE-DRAWN	BK	95.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN	JJB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2252	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206L)	NTS
DATE	09.02.03	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY COMMUNICATIONS TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	



# **LID FRAME NOTES:**

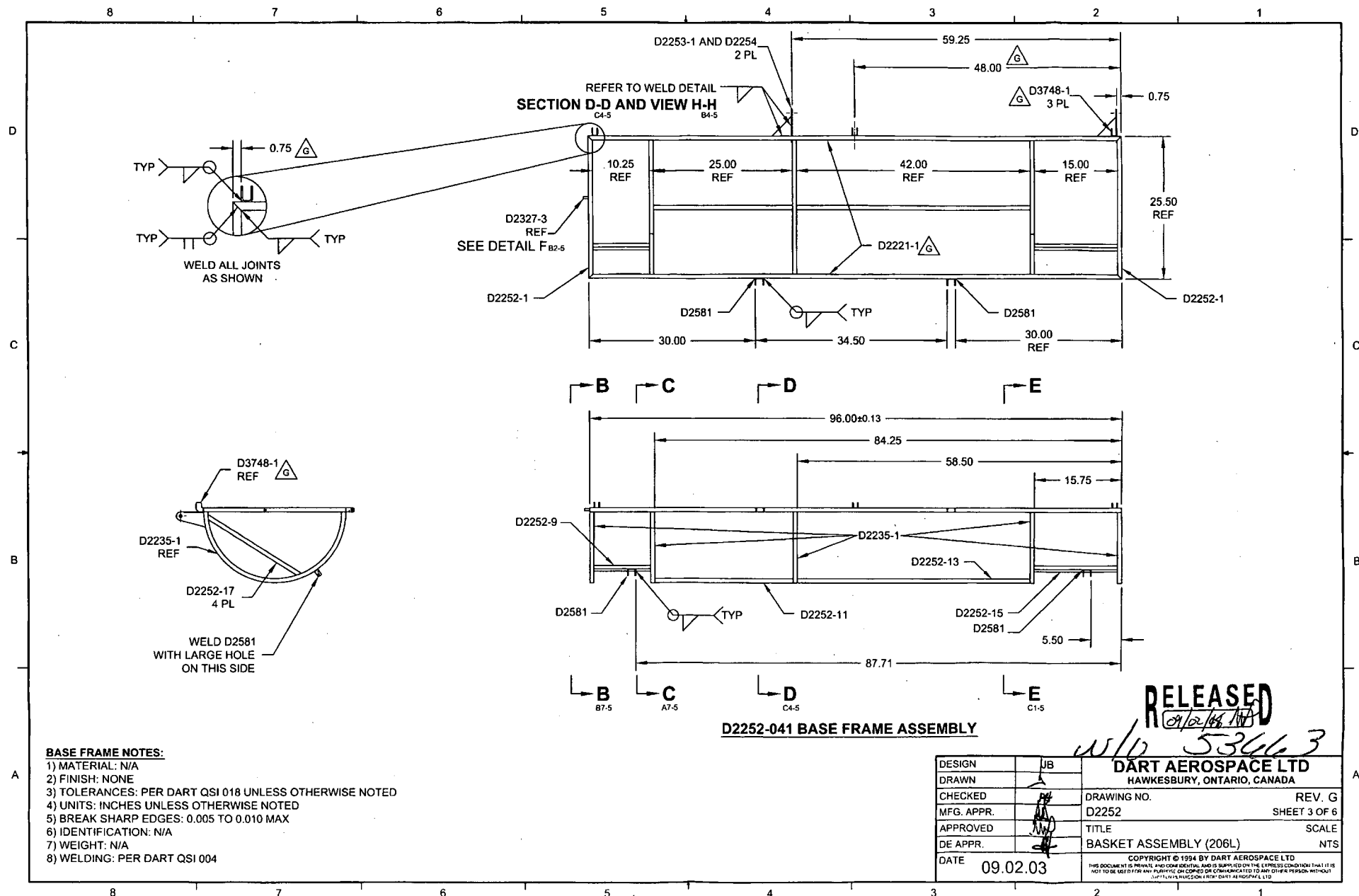
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE
- 10) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON D2252-041 BASKET BASE ASSEMBLY

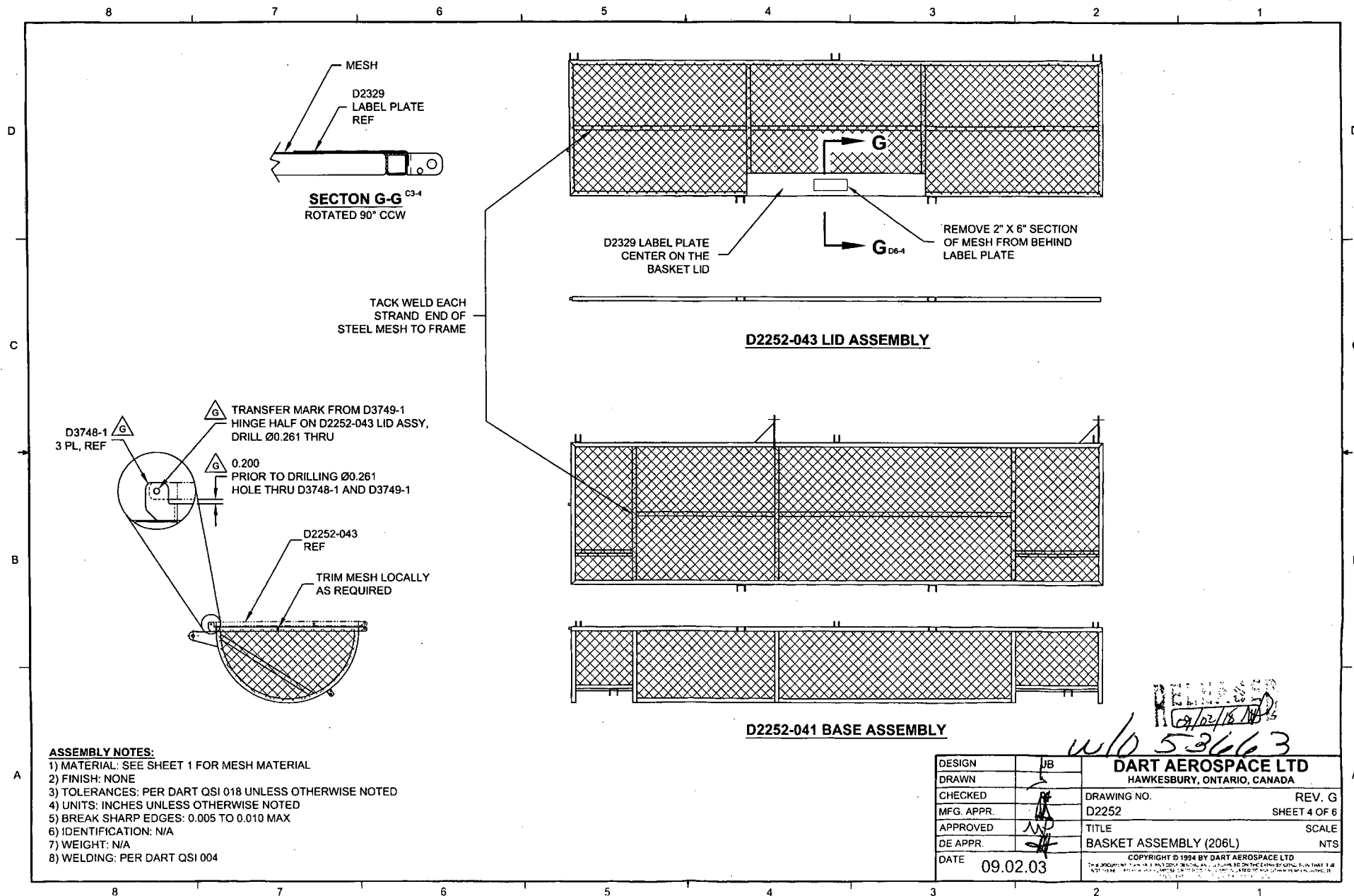
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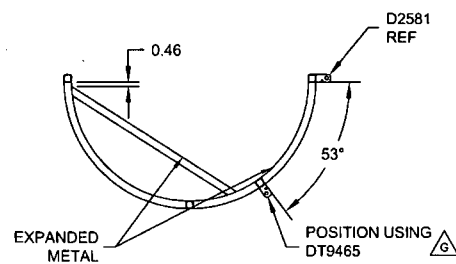
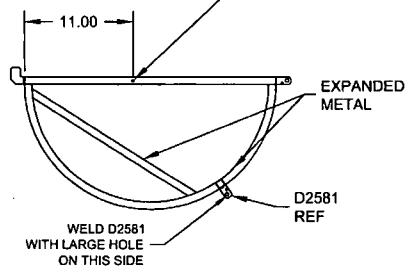
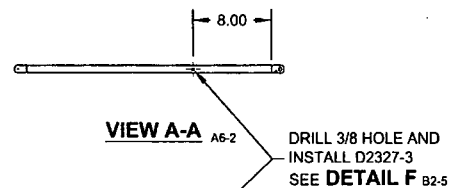
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CHECKED		DRAWING NO.	REV. G
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9/12/18

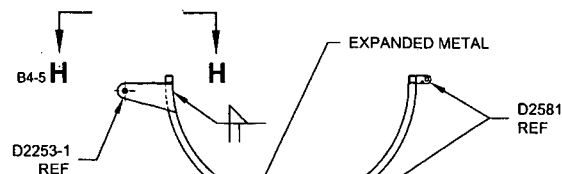
W/D 53663



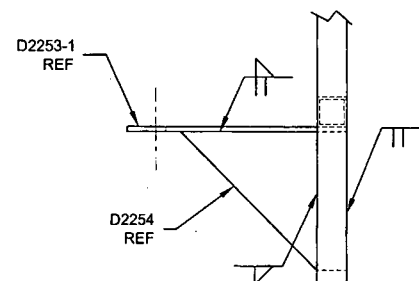




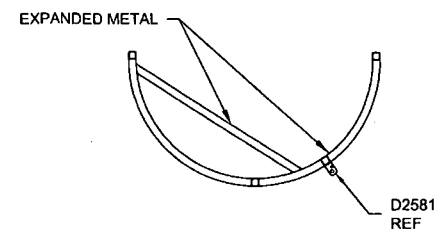
**SECTION C-C** A5-3



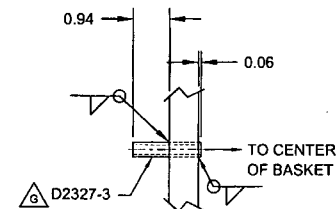
**SECTION D-D** D5-3



**VIEW H-H** D4-3 D5-5



**SECTION E-E** A2-3



**DETAIL F** C5-3  
SPACER INSTALLATION C6-2

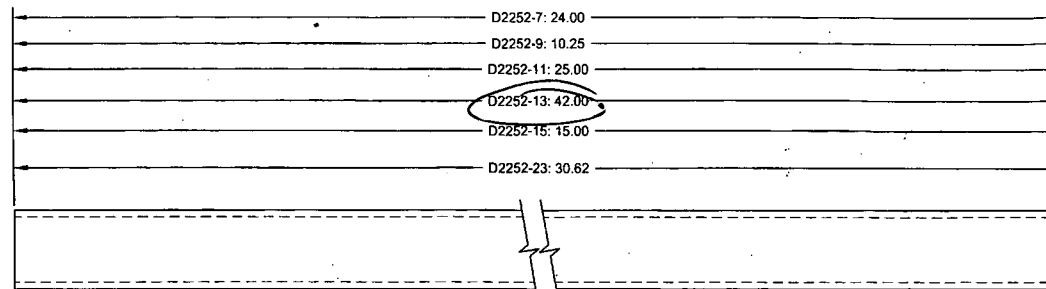
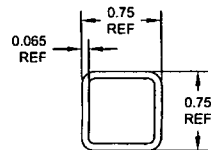
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59/02/18 MP

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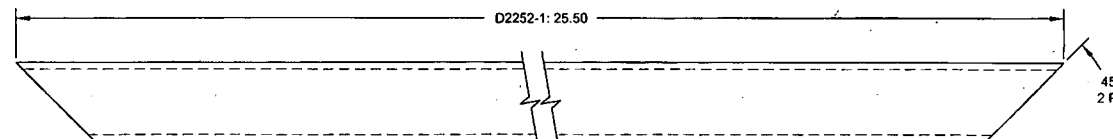
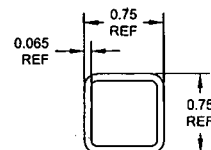
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D



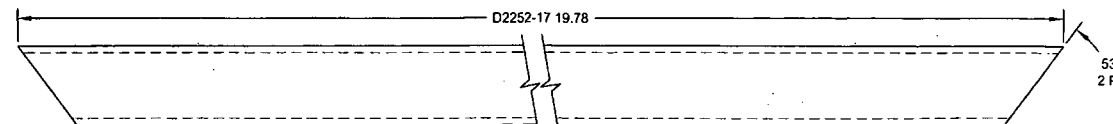
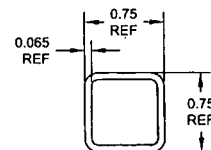
D2252-7 FRAME  
D2252-9 FRAME  
D2252-11 FRAME  
D2252-13 FRAME  
D2252-15 FRAME  
D2252-23 FRAME

C



D2252-1 FRAME

B



D2252-17 FRAME

A

- NOTES:**  
 1) FRAME MATERIAL: SEE SHEET 1  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: N/A

**RELEASED**  
*W/0 53663*

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8 7 6 5 4 3 2 1